

## ABSTRACT OF THE DISCLOSURE

A web of paper or paperboard is manufactured by first forming a base web that is dried on the press section of a papermaking machine. The base web is further dried on the dryer section of the papermaking machine and a base web speed differential, or draw, is set between the press section and the first dryer cylinder group of the dryer section, whereupon at least one surface of the web is surface sized. The draw is set to 3 % maximum, and a surface size furnish is applied having a solids content of at least 15 % of the total amount of size components and liquid in the furnish.